

WHAT IS CLAIMED IS:

Sub B2 1. A set of calender rollers comprising at least three rollers, for rolling a plastic material into a plastic material sheet and for laminating said plastic material sheet onto a base material sheet at a nip portion to be formed into a laminated plastic material sheet, wherein

said nip portion is formed with a pair of nip rollers including a holding roller for holding said rolled plastic material sheet, and behind said nip portion, a release member for releasing said laminated plastic material sheet from said holding roller is arranged in proximity to or in contact with said holding roller.

2. The set of calender rollers according to Claim 1, wherein said release member is able to be heated.

3. The set of calender rollers according to Claim 1, wherein said release member is a doctor knife.

4. The set of calender rollers according to Claim 3, wherein said doctor knife is able to be vibrated.

5. A method for producing a laminated sheet by laminating a plastic material sheet on a base material sheet using a set of calender rollers, wherein

said set of calender rollers comprises at least three rollers, a nip portion is formed with a pair of nip rollers including a holding roller for holding a rolled plastic material sheet, and behind said nip portion, a release member is arranged in proximity to or in contact with said holding roller, and a plastic material is rolled into said plastic material

sheet, then said plastic material sheet is laminated onto a base material sheet at said nip portion, and thereafter a plastic material sheet layer of said laminated sheet is released from said holding roller with said release member.

6. The method for producing a laminated sheet according to Claim 5, wherein said release member is heated at 50°C or more.

7. The method for producing a laminated sheet according to Claim 5, wherein said release member is a doctor knife.

8. The method for producing a laminated sheet according to Claim 7, wherein said doctor knife is vibrated.

9. The method for producing a laminated sheet according to any one of Claims 5, wherein said plastic material is a pressure-sensitive adhesive and said laminated sheet is a pressure-sensitive adhesive sheet.

10. The method for producing a laminated sheet according to Claim 9, wherein said pressure-sensitive adhesive is a rubber-based pressure-sensitive adhesive.

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